



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3954-7
Job Sheet 178345



Part No: D3954-7

Job Qty: 10 ea

Part Name: Ratchet Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/30/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 1,3 IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		6/15/18	0.00	0.00	Start Up Machining-2		OK 18/06/12
110	Waterjet	10 pcs		6/15/18	0.01	5.13	Waterjet1		OK 18/06/12
120	QC	10 pcs		6/15/18	0.00	0.00	QC2 Waterjet-3		OK 18/06/12
125	Mill Conv	10 pcs		6/15/18	0.00	5.62	Mill Conv 1		J.C. 18-08-21
127	QC	10 pcs		6/15/18	0.00	0.00	QC2 Machining-2		OK 18/06/12
130	QC	10 pcs		6/15/18	0.00	0.00	QC8 Machining-2		OK 18/06/12
140	Powdercoat	10 pcs		6/15/18	0.00	0.44	Powdercoat8		OK 18/06/12
150	QC	10 pcs		6/15/18	0.00	0.00	QC3		OK 18/06/12
160	Packaging	10 pcs		6/15/18	0.00	0.00	Packaging3-2		OK 18/06/12
170	QC21-SA	10 Ea		6/15/18	0.00	0.00	QC21		OK 18/06/12

Part Op 110 - 1-Cut as per Dwg D3954 2-Deburr if necessary

Descriptions: 125 - Drill and Ream hole and mill as per Dwg Pass end mill in slot 0.500"

140 - START TIME: 8:10

160 - LOCATION: WA002

OK 18/06/12

MA 1/16 372

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.000X2.000	303 Bar 1" X 2"	5 ft (.5 ea)	90-Start up Operation	M125822

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303B1.000X2.000	5	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No.: _____ NCR No.: _____ Date: _____ Step: _____ Description Work O		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐				MRB (QS042) Approval ☐	
Root Cause Environment ☐ No Re-verifica ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Centre Not Concerned ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Inspection Incomplete/Out of Spec ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Pulled ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
Completed By _____		Lead hand / Supervisor Approval _____		QC / QA Coordinator Approval _____		Other : _____			

DART AEROSPACE
Container No: S080505
Part: D3954-7
Job No: 178345
Serial No/Batch: S080505
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 06/12/18

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 CANADA
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 www.dartaerospace.com

DART AEROSPACE LTD		Work Order:	178345
Description: Ratchet Lug		Part Number:	D3954-7
Inspection Dwg: D3954	Rev: D	Page 1 of 1	

Measured by:	an/s.c.d.	Audited by:	anl	Preliminary Approval:	
Date:	18/06/12	Date:	18/06/12	Date:	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By																																																							
								Lead hand / Supervisor Approval Verification																																																							
								QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														